

Date Thursday, 16/08/2007 10:31:23 AM
User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 34006B		
Estimate Number	: 10462		
P.C. Number	:	Part Number	: D32782
This Issue	: 16/08/2007 S.O. No. :	Drawing Number	: D3278 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 33430B	Material	:
Written By	:	Due Date	: 10/09/2007 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est:A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2454 f(s)/Unit Total: 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

~~(M6061T6B1000X02000)~~ Batch: ~~M104187~~

M104187 X40

J.L. 07/09/26

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

J.L. 07/08/26

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

J.M. / J.F. 07/11/06

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.M. / J.F. 07/11/06

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:31:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 34006B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 07-11-07

(X40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

BR 07-11-07

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF 07-11-07

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location GA

MF 07-11-07

(40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U 07-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 34006 B
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098"	✓			
0.359	+/-0.005	0.361"	✓			
0.875, 0.609"	+/-0.010	0.615"	✓			
0.250	+/-0.010	0.251"	✓			
1.480	+/-0.005	1.482"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	0.121"	✓			
2.439	+/-0.010	2.439"	✓			
1.980	+/-0.010	1.978"	✓			
R0.130	+/-0.010	R0.130"	✓			
Ø0.257	+0.005/-0.000	Ø0.258"	✓			
R0.375	+/-0.010	R0.378"	✓			
0.875	+/-0.010	0.875"	✓			
0.500	+/-0.010	0.500"	✓			
R0.400	+/-0.010	R0.400"	✓			
1.720	+/-0.010	1.723"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.125	+/-0.010	0.126"	✓			

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 07/11/05	Date: 07/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

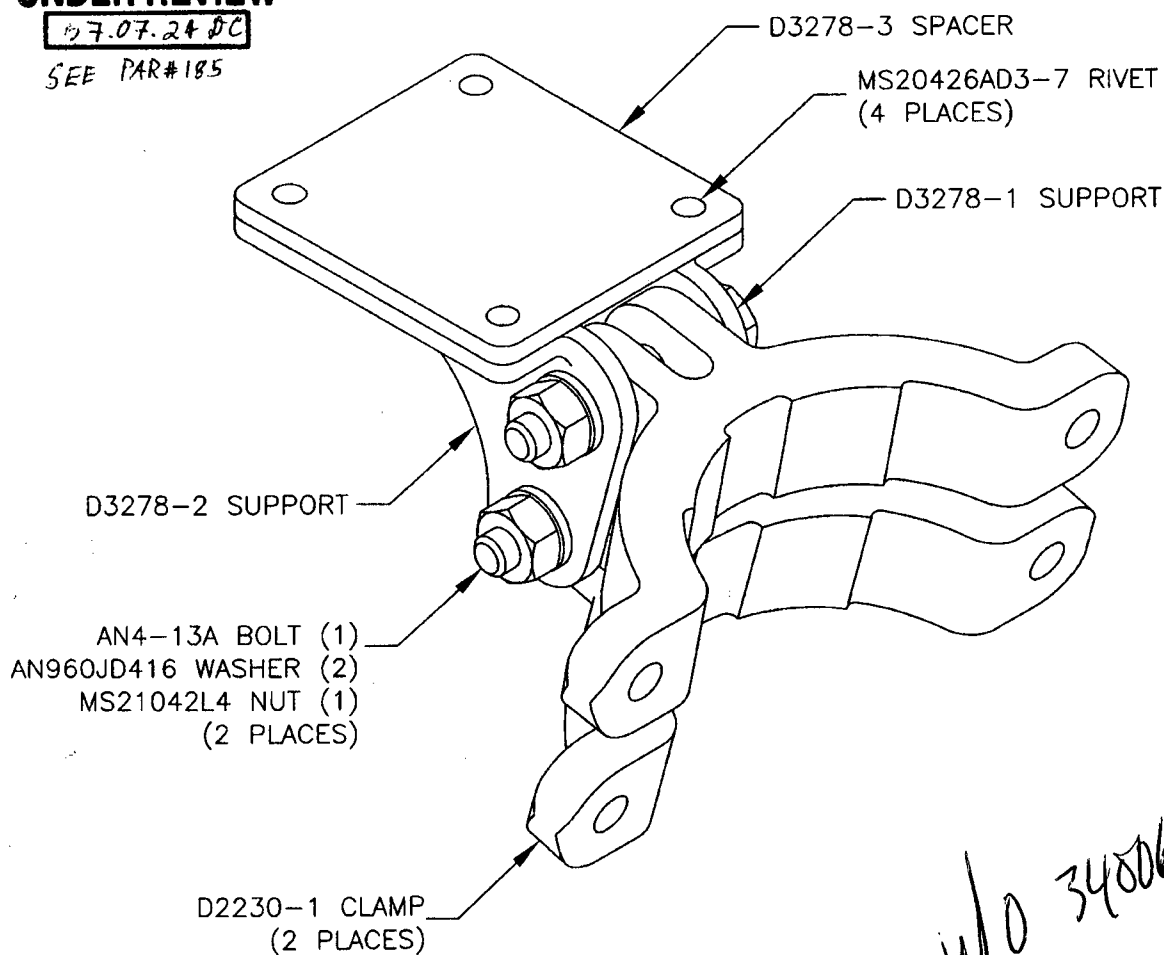
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05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY

UNDER REVIEW

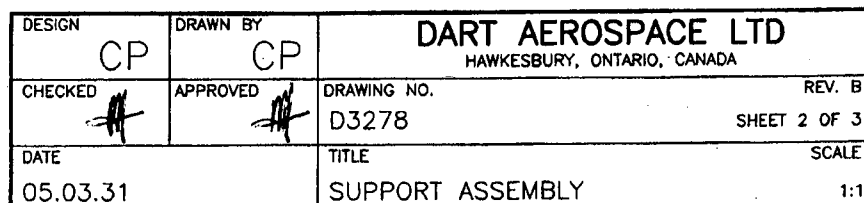
07.07.24 DC

SEE PAR#185



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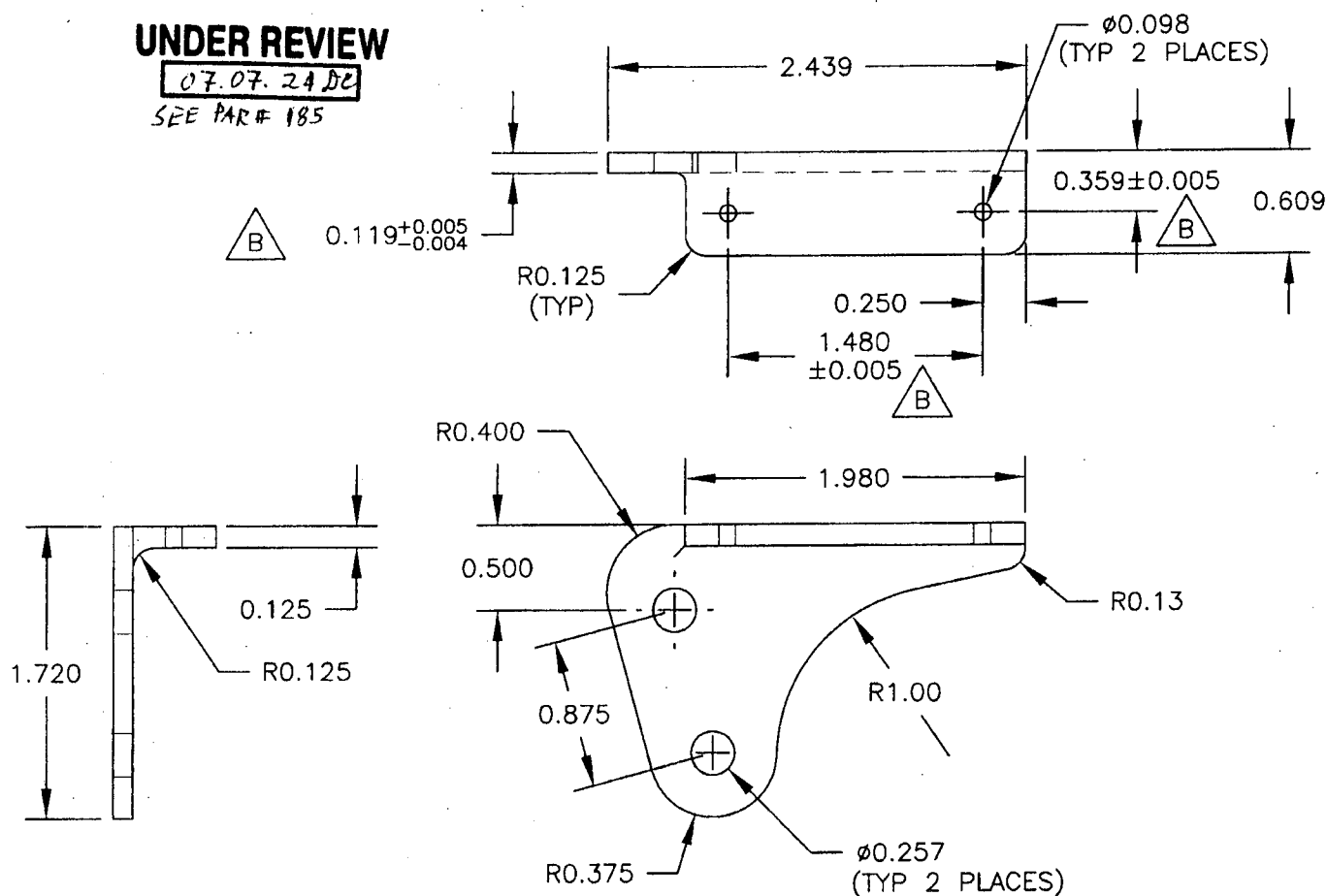
RELEASED

05.04.04

UNDER REVIEW

07.07.24 DC

SEE PAGE 185



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

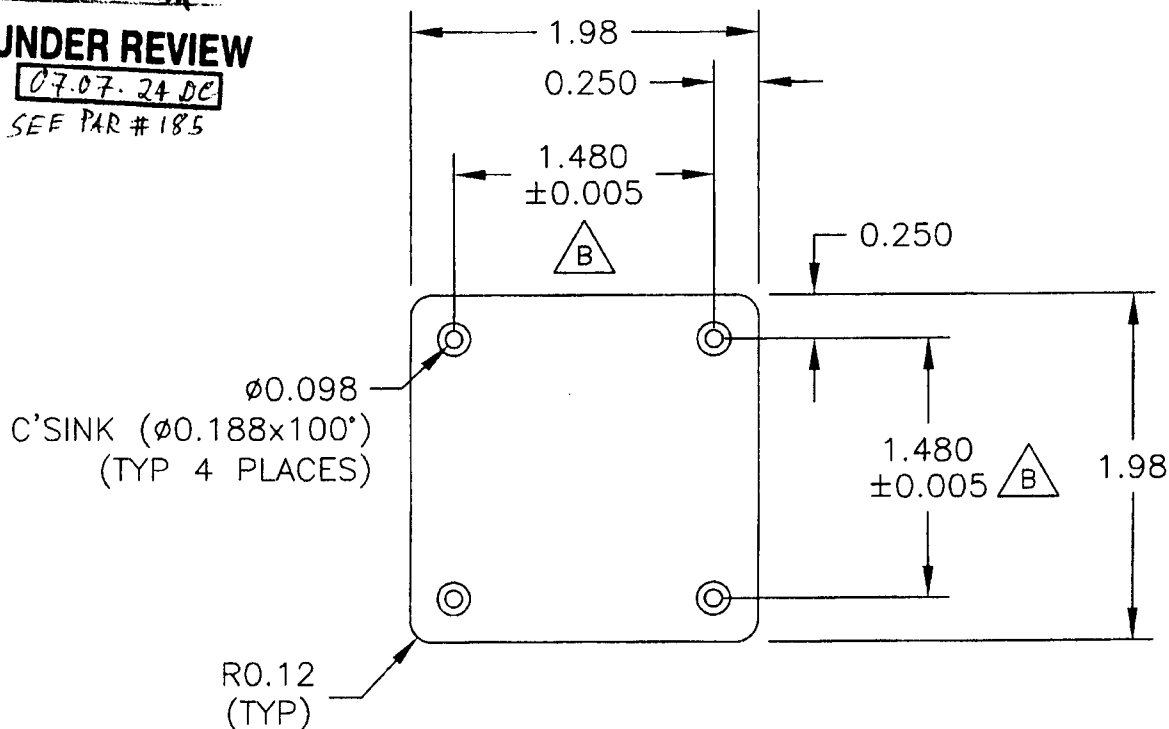
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04
UNDER REVIEW
07.07.24 DC
SEE PAR #185



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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